



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18604
Job Sheet 191213



Part No: RBT18604

Job Qty: 2 pcs

Part Name: Tail Rotor Swashplate Bearing ReGrease Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 13911*

Note: DWG RBT18604 Rev.5 IPP Rev. A 18.10.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	2/28/19		0.00	2.00	Small Fab - 1		<i>MCC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	2/28/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	2/28/19		0.00	0.00	Packaging 3 - 1 - B4B		<i>DAS 28 9-89</i>
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S158449



Part: RBT18604

Job No: 191213

Serial No/Batch: S158449

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 03/04/19

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				Packaging 3 - 8 - B4B						
				Packaging 3 - 9 - B4B						
				Packaging 3 - 10 - B4B						
				Packaging 3 - 11 - B4B						
				Packaging 3 - 12 - B4B						
				Packaging 3 - 13 - B4B						
				Packaging 3 - 14 - B4B						
				Packaging 3 - 15 - B4B						
				Packaging 3 - 16 - B4B						
				Packaging 3 - 17 - B4B						
				Packaging 3 - 18 - B4B						
				Packaging 3 - 19 - B4B						
				Packaging 3 - 20 - B4B						
				Packaging 3 - 21 - B4B						
				Packaging 3 - 22 - B4B						
				Packaging 3 - 23 - B4B						
				Packaging 3 - 24 - B4B						
				Packaging 3 - 25 - B4B						
				Packaging 3 - 26 - B4B						
				Packaging 3 - 27 - B4B						
				Packaging 3 - 28 - B4B						
				Packaging 3 - 29 - B4B						
				Packaging 3 - 30 - B4B						
				Packaging 3 - 31 - B4B						
				Packaging 3 - 32 - B4B						
				Packaging 3 - 33 - B4B						
				Packaging 3 - 34 - B4B						
				Packaging 3 - 35 - B4B						
				Packaging 3 - 36 - B4B						
				140	QC 21 - FG	2 pcs	2/28/19	0.00 0.00	QC 21 - FG - 21	DAG
									QC 21 - FG - 70	21
									QC 21 - SA - 53	9-05 MAR 05 2019

Part Op **110** - (Small Fab) 1-Assemble as per DWG.
 Descriptions: **120** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____) The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1095K41	Zerk	2 Ea (1 ea)	110-Small Fab - 1	5075943
2-230	O-Ring	2 Ea (1 ea)	110-Small Fab - 1	5122105
RBT18604-1	Body	2 pcs (1 ea)	110-Small Fab - 1	5122854
RBT18604-3	Plug	2 pcs (1 ea)	110-Small Fab - 1	5135457

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	1095K41	2	6	0
	2-230	2	101	0
	RBT18604-1	2	3	0
	RBT18604-3	2	2	0

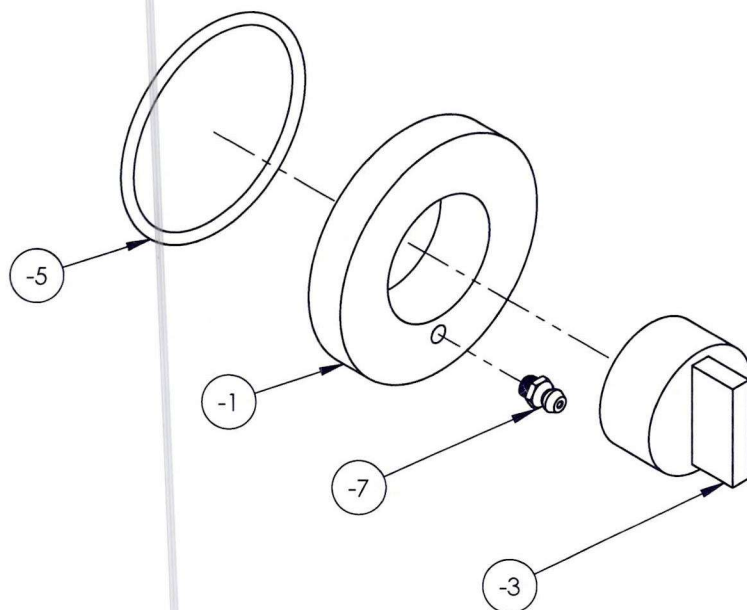
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DISTANCE FROM FACE TO STEP INCREASED TO .30 TO ENSURE ADEQUATE THREAD ENGAGEMENT.	3/9/2001		
2		O-RING GROOVE ENLARGED TO BETTER FIT O-RING.	3/23/2001	DW	
3		DISTANCE FROM FACE TO STEP REDUCED TO .265.	4/4/2001		
4		GREASE FITTING CH'D TO 45° FOR EASE OF USE, MUST FACE OUT.	2/10/2003		
4A		CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL. -1 CH'D ENGRAVE NOTE, LABELED SECTION VIEW.	1/13/2010	RJC	
5	16-0202	-1 CH'D DIM WAS Ø3.00 CLEANUP IS Ø3.00 ±.02, WAS Ø.09 THRU $\perp$ Ø.213 ∇ 1/4, 1/4-28 UNF FOR GREASE FITTING IS Ø.09 THRU ALL 1/4-28-28 ∇ .25, WAS BORE Ø1.505 +.012/- .000 & THREAD 1.563-18 UNJS-3B PER MIL 8879 IS 1.563-18 UNJS-3B THRU ALL. -3 DELETED DIM .63, ADDED DIM'S 1.38, .65, .13, CH'D MATERIAL WAS NYLON OR DELRIN IS WHITE DELRIN/ACETAL. -5 CH'D B/O INFO WAS PARKER #2-230 IS Ø1/8 X C.S. X Ø2-1/2 I.D. X Ø2.75 (#2-230) CHRISTOPHER SEALS). MAT'L IS BUNA-N. -7 CH'D B/O INFO WAS MSC #08060725 OR EQUIVELENT IS MCMaster-CARR #1095K41.	10/24/2016	RJC	JAG



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WORK ORDER

NO. 191213 MJS
19-02-25

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061		2
			-3	1	PLUG	WHITE DELRIN/ACETAL		3
		B/O	-5	1	O-RING	BUNA-N	Ø1/8 C.S. X Ø2-1/2 I.D. X Ø2.75 (#2-230) (CHRISTOPHER SEALS)	1
		B/O	-7	1	GREASE FITTING	STEEL	STRAIGHT 1/4-28 SAE-LT MALE (MCMaster-CARR #1095K41)	1

DART AEROSPACE	
TITLE REGREASE TOOL - SWASH PLATE	
DWG NO. RBT18604	REV 5
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT None	.XXX ± .005 FRACTIONS ± 1/8
FINISH None	.XX ± .01 ANGLES ± .5°
SPEC None	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD 369 D, E, & F
SCALE 1:2	DATE 10/24/2016
SHEET 1 OF 3	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					